

Date: Wednesday, 3/8/2006 10:47:34 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GAS SPRING ASSEMBLY
Job Number	: 26155		
Estimate Number	: 10181		
P.O. Number	: N/A	Part Number	: D2153
This Issue	: 3/8/2006 S.O. No. : N/A	Drawing Number	: D2153 REV. A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: A1
Previous Run	: 25940	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 3/15/2006
Checked & Approved By	: <u>06.03.08</u>	Qty:	36 Um: Each
Comment	: Est: E 02.07.08 Re-format KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 732

Gas Spring P/N: SL13-10 (10lb)

Possible supplier: Spring Lift Corporation

Note: Do not ship by air**

Allow an extra 7 to 10 business days for shipping**

Material release note is required

U 06.03.09

2.0	D2153P	Door Prop
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 15.0000 Each(s)
 GAS SPRING ASSEMBLY

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

PU #13/14

(36)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Inspect Test Spring is 10lb

06.03.14

(36)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/8/2006 10:47:34 AM
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Process Sheet

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Drawing Name: GAS SPRING ASSEMBLY

Job Number: 26155

Part Number: D2153

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D30153

Lock Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 30.0000 Each(s)

Lock Nut

Pick:

Qty Part Number

Description

Batch

2 D3015-3

Lock nut

B25149

(72)

6.0

AN960JD516

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 30.0000 Each(s)

Washer

Pick:

Qty Part Number

Description

Batch

2 AN960JD516

Washer

m18100

(72)

7.0

SL69BS

Ball Stud



Comment: Qty.: 2.0000 Each(s)/Unit Total : 30.0000 Each(s)

Ball Stud

Pick:

Qty Part Number

Description

Batch

2 SL69-BS

Stud

m100369

(72)

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per Dwg D2153

2- Remove Spring Lift name and address with Acetone, leave only warning:

"DO NOT OPEN HIGH PRESSURE"

(36)

ml 06/03/15

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-03-15

36

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57 218

06/03/17

36

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: LD Date: 06/03/21
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GAS SPRING ASSEMBLY

Job Number: 26155

Part Number: D2153

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

32
06/03/21

Job Completion



06.03.21

Dart Aerospace Ltd

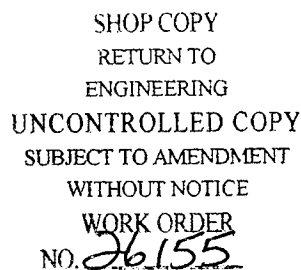
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
96/107/16

01.05.09	CHANGE TO P&IS-3	SL 13-10	W/MT SL33-15	REVISION	<p>THE DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.</p> <p>REQUIREMENTS — UNLESS OTHERWISE SPECIFIED</p> <table border="1"> <thead> <tr> <th>GENERAL</th> <th>LIMITS</th> </tr> </thead> <tbody> <tr> <td>1. DIMENSIONS ARE IN INCHES</td> <td>1. TOLERANCES — .001 & .020</td> </tr> <tr> <td>2. DIMENSIONS ARE IN MILLIMETERS</td> <td>2. ANGLES 30° & 45°</td> </tr> <tr> <td>3. REMOVE SHARP EDGES .015 MAX</td> <td>3. PARALLELISM .005 MAX</td> </tr> <tr> <td>4. THREADS PER INCH — S — 1742</td> <td>4. ECCENTRICITY .005 MAX</td> </tr> <tr> <td>5. HOLES PER AND 10087</td> <td>5. ALL MAX CENTER LINES .005</td> </tr> </tbody> </table>	GENERAL	LIMITS	1. DIMENSIONS ARE IN INCHES	1. TOLERANCES — .001 & .020	2. DIMENSIONS ARE IN MILLIMETERS	2. ANGLES 30° & 45°	3. REMOVE SHARP EDGES .015 MAX	3. PARALLELISM .005 MAX	4. THREADS PER INCH — S — 1742	4. ECCENTRICITY .005 MAX	5. HOLES PER AND 10087	5. ALL MAX CENTER LINES .005	<p>PIVET CODE SHALL BE PER MAS 523</p> <table border="1"> <thead> <tr> <th>BASIC CODE</th> <th>DIA. DASH NO. H-HEAD NEAR SIDE</th> <th>LENGTH DASH NO. W-SPOTWELD</th> </tr> </thead> <tbody> <tr> <td>D-DIMPLE</td> <td></td> <td></td> </tr> <tr> <td>C-COUNTERSINK</td> <td></td> <td></td> </tr> </tbody> </table>	BASIC CODE	DIA. DASH NO. H-HEAD NEAR SIDE	LENGTH DASH NO. W-SPOTWELD	D-DIMPLE			C-COUNTERSINK			<p>PART NO.</p> <p>CONTRACT NO.</p> <p>DATE</p> <p>DESIGN</p> <p>STRESS</p> <p>CHECKED</p> <p>CHECKED</p>	<p>ITEM</p> <p>DESCRIPTION</p> <p>MATERIAL</p> <p>SPEC./VENOOR</p>
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COMMERCIAL INVOICE

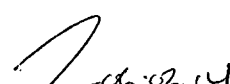
Page: 1

FROM		
Tax ID: 364308711 Contact Name: Trisha Smith Attwood Corporation 1016 N Monroe Lowell MI 49331 UNITED STATES Phone: 616 897-9241		
SHIP TO		
Tax ID: Contact Name: DART AERO LTD. 1270 ABERDEEN STREET HAWKESBURY ON K6A 1K7 CANADA Phone: 613-632-3336		

Shipment ID: 4545743FX8B	
ø4545743FX8BHø	
Invoice No: 3844370003 Date: 09/MAR/2006 PO No: Terms of Sale (Incoterm): FOB Reason for Export: Sale	
SOLD TO INFORMATION	
Tax ID: Contact Name: DART AERO LTD. 1270 ABERDEEN STREET HAWKESBURY ON K6A 1K7 Phone: 613-632-3336	

Units	U/M	Description of Goods	Harm. Code	C/O	Unit Value	Total Value
36 EA	SL13-10-1	GAS SPRING 15" EXTC 10# BL SCKT ✓	8302.49.6035	NZ	7.640000	275.04
100 EA	SL69-BS-1	10MM BALL STUD W/THRD	7318.15	US	0.660000	66.00
100 EA	SL69-BS-1	10MM BALL STUD W/THRD	7318.15	US	0.660000	66.00

Additional Comments:

Declaration Statement:	
I HEREBY CERTIFY THAT THE INFORMATION ON THIS INVOICE IS TRUE AND CORRECT AND THE CONTENTS AND VALUE OF THIS SHIPMENT IS AS STATED ABOVE.	
Shipper	Date
	03/09/2006

Invoice Line Total: Discount/Rebate: Invoice Sub-total: Freight: Insurance: Other: Total Invoice Amount:	407.04 0.00 407.04 21.00 0.00 0.00 428.04
Total Number of Packages: Total Weight:	2 17.30
Currency:	USD Lbs.

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